

Date: Wednesday, 1/11/2006 4:25:08 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SUPPORT BRACKET
<b>Job Number</b> : 25451	
<b>Estimate Number</b> : 10260	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D23623
<b>This Issue</b> : 1/11/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2362 REV E1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E1
<b>Previous Run</b> : 25073	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 1/18/2006
<b>Checked &amp; Approved By</b> : SEE COMMENT BELOW	<b>Qty</b> : 10 <b>Um</b> : Each
<b>Comment</b> : Est: G 00.05.18 Added inspection level 8 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2265	Step Support Casting
-----	-------	----------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	625401-1

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** Machine per folio D2362-3

SD 06.01.28

9

P10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** Inspect Level 2

SD 06.01.28

9

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

BG 06.01.30

9

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

SD 06.01.28

9

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



**Comment:** POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3




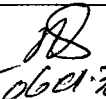
DL 06/01/30

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/31

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.01.28	2	- part hit by tool ↳ modify program. → done		Note held in Colia / program changed	SA 06.01.28	 06.01.28		 06.01.30

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:25:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 25451

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*206-01-31*

Comment: INSPECT POWDER COAT

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

*B25659 (5)*  
*B25469 (4)*

*mlo6/01/30*

9

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

*B25660 (5)*  
*B25470 (4)*

*mlo6/01/30*

9

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch *M16194*

*mlo6/01/30*

9

11.0

QC5

INSPECT WORK TO CURRENT STEP



*206-01-31*

Comment: INSPECT WORK TO CURRENT STEP

9

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *172*

*C206/01/31*

*(9)*

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



*N 06-01-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**



**RELEASED**  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	#	D2362
DATE	TITLE	SHEET 1 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2

REV.	DATE	DESCRIPTION
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

**UNDER REVIEW**

03.10.07 CP

DESIGN OK, BUT CHECK WITH  
3B BEFORE MANUFACTURE  
OK 04/11/07

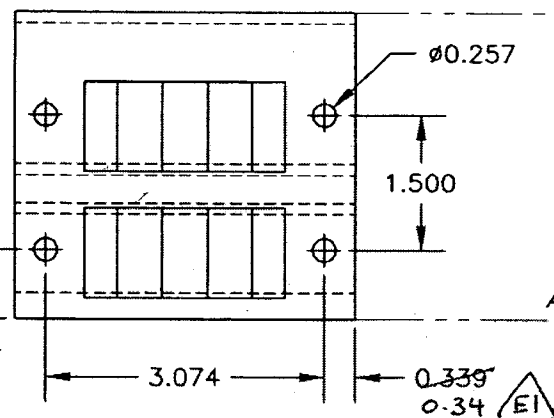
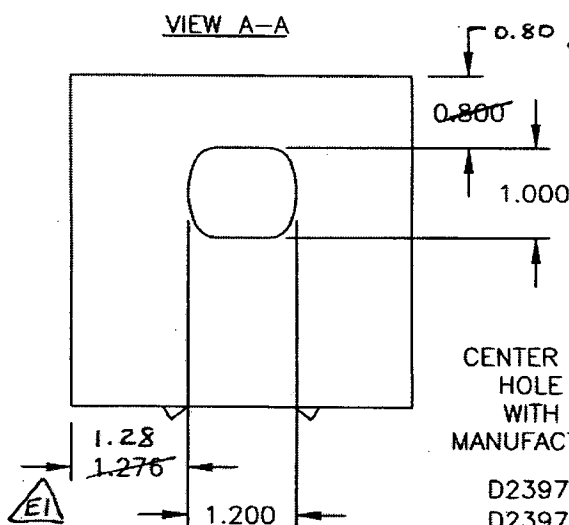
0.257 X 0.75 SLOT

REMOVE TIPS  
FROM CASTING  
MAX 0.080

CENTER D2397-1/-3 RUBBER  
HOLE WITH SLOT AND BOND  
WITH CONTACT CEMENT PER  
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)  
D2397-3 RUBBER CUSHION (1)

VIEW A-A



D2362-3

0.77  
0.767  
TURN TO  
ENGINEERING  
FOR ROLLED COPY  
NOT TO AMEND  
WITH OUT NOTICE

MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1995 by DART AEROSPACE LTD

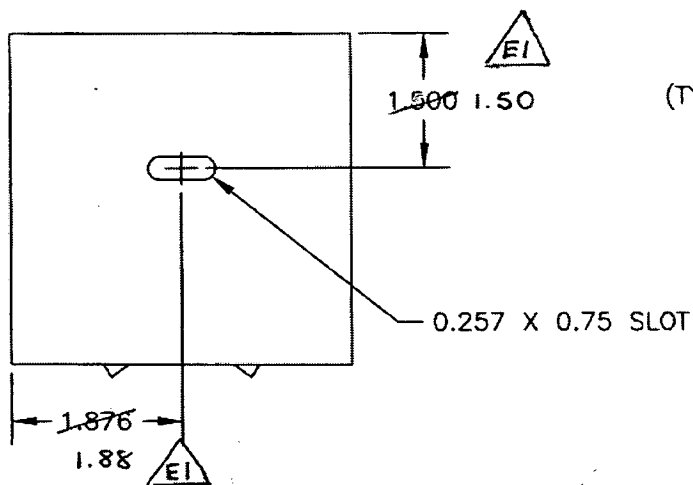
WORK ORDER

NO. 2448 25451



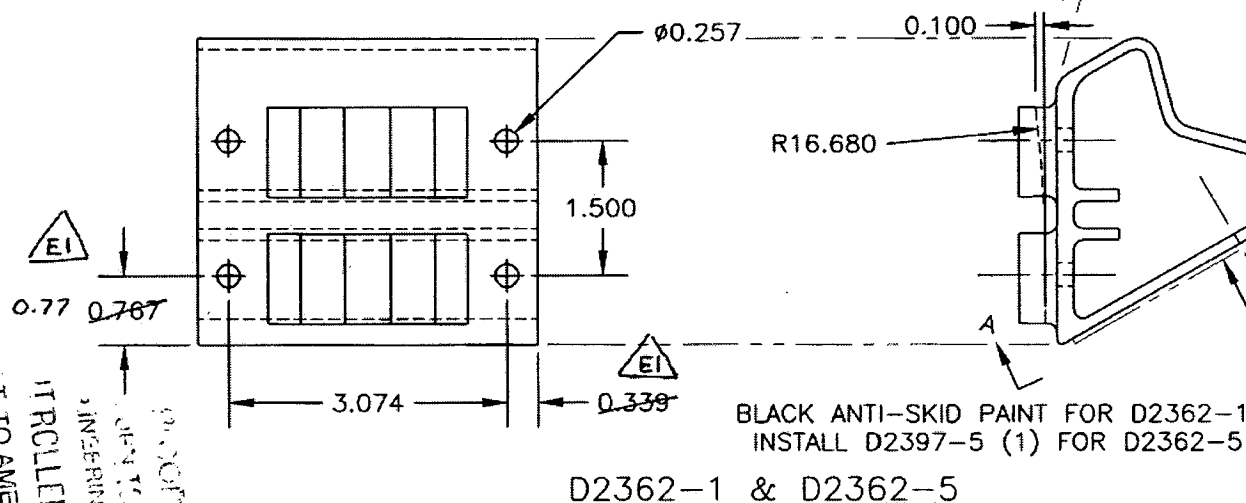
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2362	SHEET 2 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	

VIEW A-A



MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1  
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

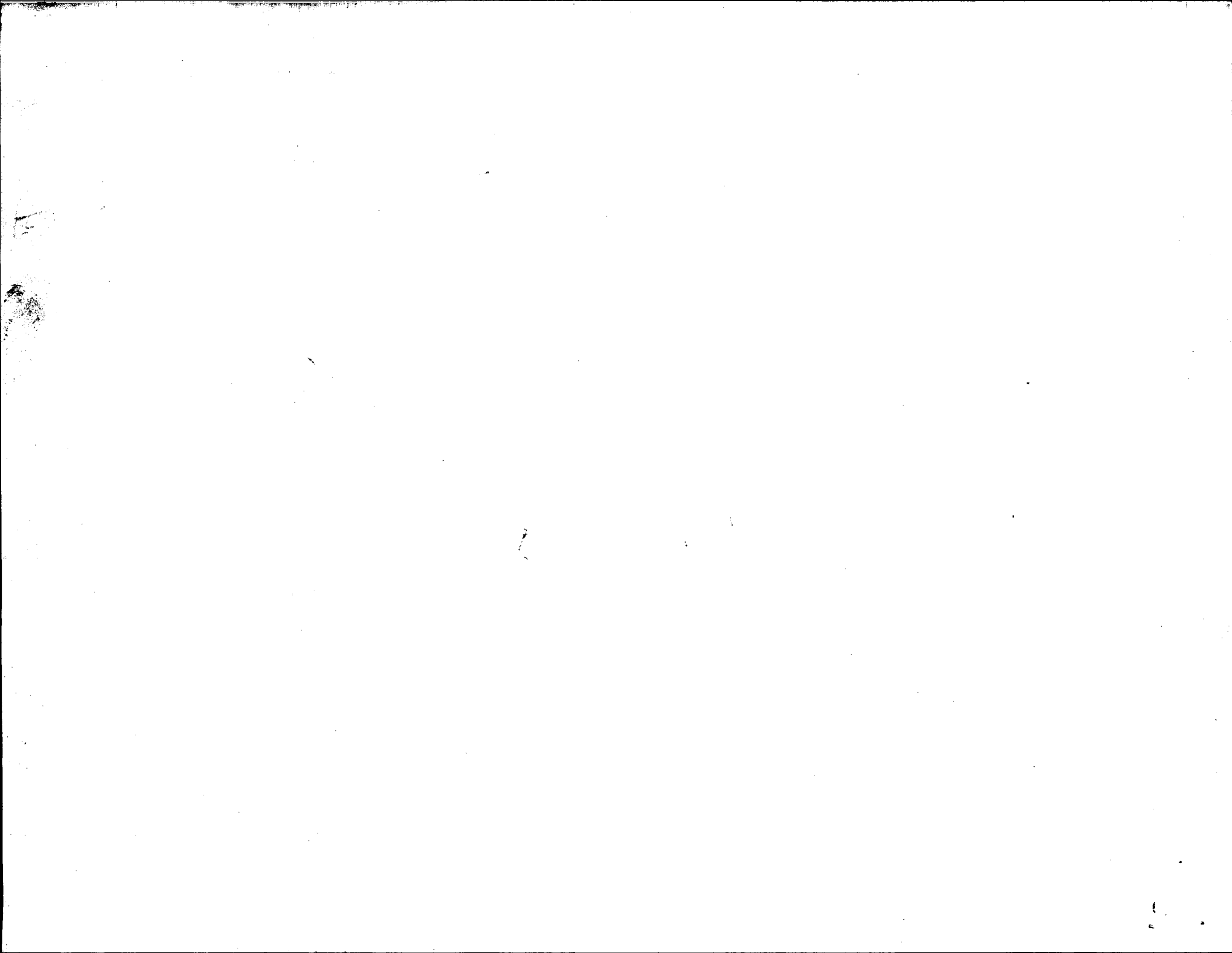
RELEASED  
98.12.14  
UNDER REVIEW  
KE

DESIGNED, BUT CHECK BY  
OR BEFORE MANUFACTURE  
OK 1/24/09

Copyright 1995 by DART AEROSPACE LTD WITH OUT NOTICE

WORK ORDER

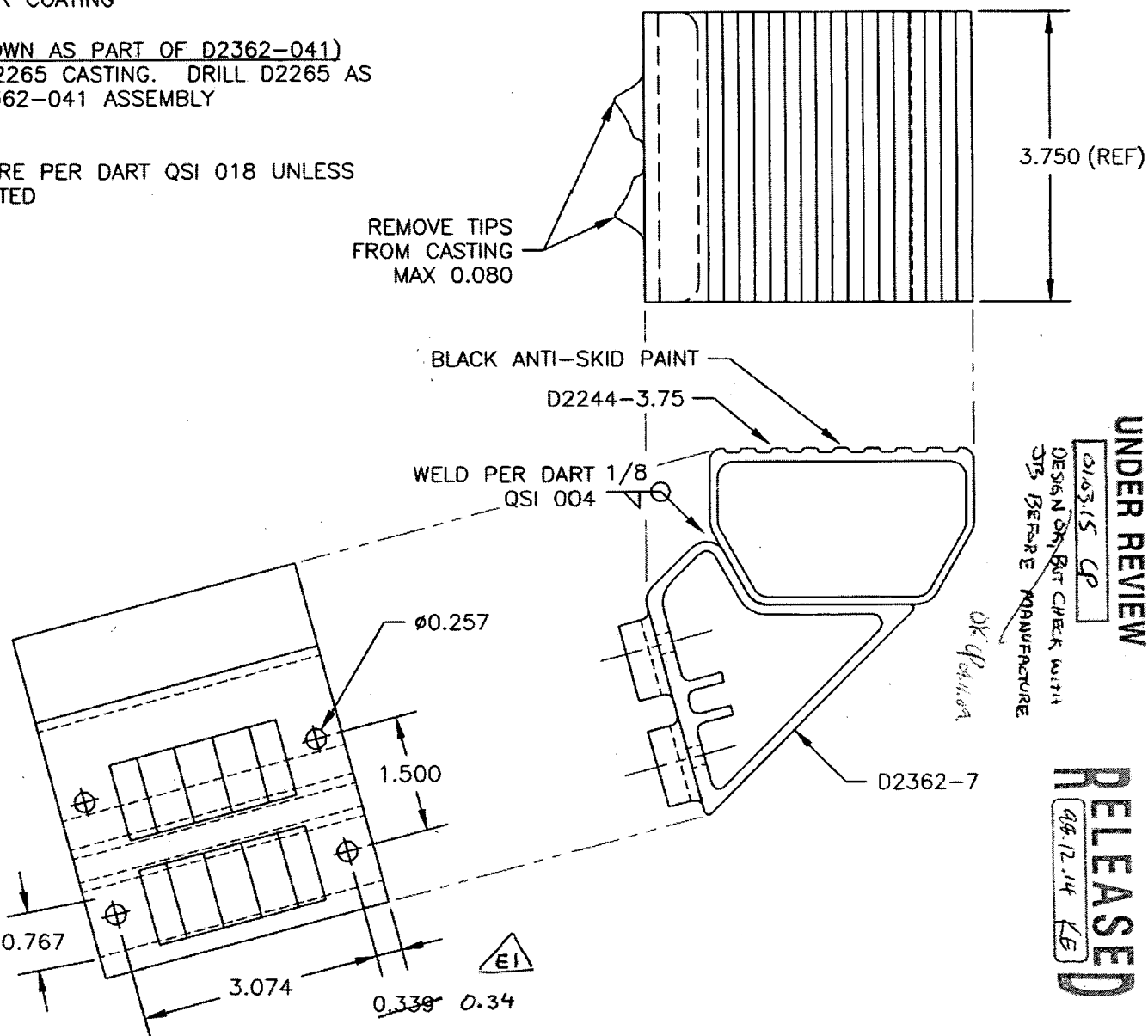
NO. 25451



FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:  
TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



**UNDER REVIEW**

RELEASED  
98-12-14 KB

**DART**



DESIGN	DRAWING NO.		REV. E
BW	HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	D2362	SHEET 3 OF 3
DATE	TITLE		SCALE
98.12.04	STEP SUPPORT BRACKET		1:2

Copyright 1995 by DART AEROSPACE LTD

WORK ORDER

NO. 2545-1





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 25451
<b>Description:</b>		<b>Part Number:</b>
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.80	$\pm .030$	.778	/			
1.000	$\pm .010$	1.002	/			
1.200		1.201	/			
1.28	$\pm .030$	1.267	/			
.257	$\pm$	.259	/			
.75	$\pm .030$	.760	/			
1.88		1.87	/			
1.00		.987	/			
Ø.257		Ø.258	/			
1.500	$\pm .010$	1.503	/			
.34	$\pm .030$	.338	/			
3.074	$\pm .010$	3.067	/			
.77	$\pm .030$					Cannot measure accurately

<b>Measured by:</b> SD	<b>Audited by:</b>	<b>Prototype Approval:</b>
<b>Date:</b> 06.07.28	<b>Date:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	